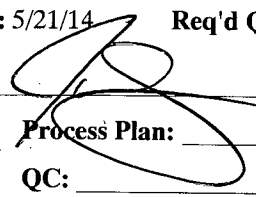


Work Order ID 119353

February-20-15 9:11:26 AM

119353

Page 1

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd, Out
 Start Date: 5/21/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference: 

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								

100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								DAS 14 9-89
HAAS 1	Memo	0.00				12	6		15/02/25 JFE
HAAS CNC vertical machine #1	Program Batch No. <u>119353</u>								2015-03-07
	Double check by: <u>B.A.</u>								
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets								
	2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets								
	3-Machine Step No 3 per Folio FA051 and inspect								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00				12	6		JFE 2015-03-07
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572								

February-20-15 9:11:26 AM

Page 2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

Work Order ID 119353

February-20-15 9:11:26 AM

119353

Page 3

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd, Out
 Start Date: 5/21/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M124808</i> Memo START TIME: <i>8:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>9:20</i>	0.00 0.00						<i>12</i> <i>15-3-24</i>	<i>DAS</i> <i>34</i> <i>9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>12</i>	<i>DAS</i> <i>38</i> <i>9-89</i> <i>MAR 24 2015</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>st 397</i> Memo	0.00 0.00						<i>DAS</i> <i>27</i> <i>9-89</i> <i>MAR 25 2015</i>	

Work Order ID 119353***119353***

Page 4

February-20-15 9:11:26 AM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Fwd, Out
Start Date: 5/21/14 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/21/14 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 1503-25
mk
15-3-25

Picklist Print

February-20-15 9:11:26 AM

Page 1

Work Order ID: 119353

119353

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 5/21/14

Required Date: 5/21/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	48.0000	1	12			

D6101-007

Saddle Billet

on 15/02/25

Location

Loc Qty

Loc Code

MAT041

21

121646

1

127646

20

MAT044

27

→ 116083

17

119005

2

120494

7

76839

1

12

DART AEROSPACE LTD	Work Order: 119353
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.503	.505		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.499	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.568	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.125	.125	.124		
R	0.240	0.260		.257	.252	.252	.252		
S	0.115	0.135		.130	.130	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.957	2.957	2.958		
V	0.230	0.250		.235	.238	.239	.240		
W	0.115	0.135		.124	.124	.124	.123		
X	0.308	0.313		.310	.3117	.312	0.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.628	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.248	.248	.250		
AE	1.375	1.395		1.388	1.390	1.389	1.388		
AF	0.115	0.135		.135	.134	.135	.135		
AG	0.240	0.280		.264	.264	.264	.264		
AH	0.240	0.260		.244	.248	.249	.249		
AI	2.000	2.020		2.0037	2.006	2.003	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>DM</i>	Audited by: <i>DM</i>	DAS
Date: 15/02/25	Date: 15/03/18	08
		9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 119353
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		0.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	8.001	8.000		
F	0.490	0.510		0.5035	0.5035	0.5025	0.5025		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		0.499	0.500	0.499	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5625	0.5625	0.562	0.562		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		.124	0.123	0.124	0.124		
R	0.240	0.260		0.251	0.254	0.254	0.254		
S	0.115	0.135		0.129	0.129	0.129	0.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.240	0.239	0.240		
W	0.115	0.135		0.121	0.120	0.120	0.120		
X	0.308	0.313		0.3115	0.3115	0.3115	0.3115		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		0.249	0.249	0.249	0.249		
AE	1.375	1.395		1.387	1.388	1.390	1.3895		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.264	0.264	0.264	0.264		
AH	0.240	0.260		0.251	0.253	0.250	0.250		
AI	2.000	2.020		2.000	2.001	2.003	2.0019		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: 14 JFC	Audited by: DAS
Date: 15/03/06 2015-3-7	Date: 15/03/18 08 9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 119353
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	311	412		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	8.001	7.999		
F	0.490	0.510		0.505	0.503	0.505	0.503		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.564	0.564	0.564	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.122	0.121	0.122	0.121		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.129	0.129	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.963	2.960	2.961		
V	0.230	0.250		0.241	0.239	0.242	0.240		
W	0.115	0.135		0.121	0.121	0.122	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.247	0.250	0.250		
AE	1.375	1.395		1.388	1.3895	1.387	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.264	0.264	0.264	0.264		
AH	0.240	0.260		0.250	0.247	0.250	0.247		
AI	2.000	2.020		2.005	2.003	2.003	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JFC
Date: 2015-3-8

Audited by: D.A	DAS
Date: 15/03/18	08
	9.89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

